

Date: Thursday, 3/2/2006 3:07:31 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 26028	
Estimate Number : 10196	
P.O. Number : NIA	Part Number : D21751 <i>[-2: 2628 wlp]</i>
This Issue : 3/2/2006 S.O. No. : NIA	Drawing Number : D2175 REV. D
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA Type : MACHINED PARTS	Drawing Revision : D
Previous Run : NIA	Material : NIA
Written By : <i>SEE COMMENT BELOW</i>	Due Date : 3/25/2006 Qty: 40 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est E 04.06.09 Reformat KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
Comment: Qty.: 0.4958 sf(s)/Unit Total : 19.8324 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Batch: <i>M19059</i> <i>ml 06/03/18</i> <i>40</i>		
2.0	SHEAR	SHEAR
Comment: SHEAR Cut blank: 12.75" x 2.95" Grain along 2.95" <i>ml 06/03/18</i> <i>40</i>		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA083 and Dwg D2175 Stack of 10 Identify as D2175-1 <i>ml 06/03/18</i> <i>40</i>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>ml 06/03/18</i> <i>40</i>		
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>ml 06/03/18</i> <i>40</i>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/03/27	7	2 piece was wrap bend on wrong way	JB 06/03/27	Scrap destroyed	SPB 06/03/27	2 06/03/27	JB 06/03/27	2 06/03/27

NOTE: Date & initial all entries

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Part Number: D21751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

SAD 06-07-20

(39)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

JB 06/03/27

(38)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-28 (38)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-03-31

(38)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

DL 06/04/01

(38)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST220

D2175-1

Qty

19

D2175-2

19

CL 06/04/03

(38)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/04/04

Job Completion



u 06-04-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	26028
Description: Angle	Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

<input checked="" type="checkbox"/> First Article	<input type="checkbox"/> Prototype
<p>1. Introduction</p> <p>2. Materials and Methods</p> <p>3. Results</p> <p>4. Discussion</p> <p>5. Conclusion</p>	<p>1. Introduction</p> <p>2. Materials and Methods</p> <p>3. Results</p> <p>4. Discussion</p> <p>5. Conclusion</p>

[illegible]

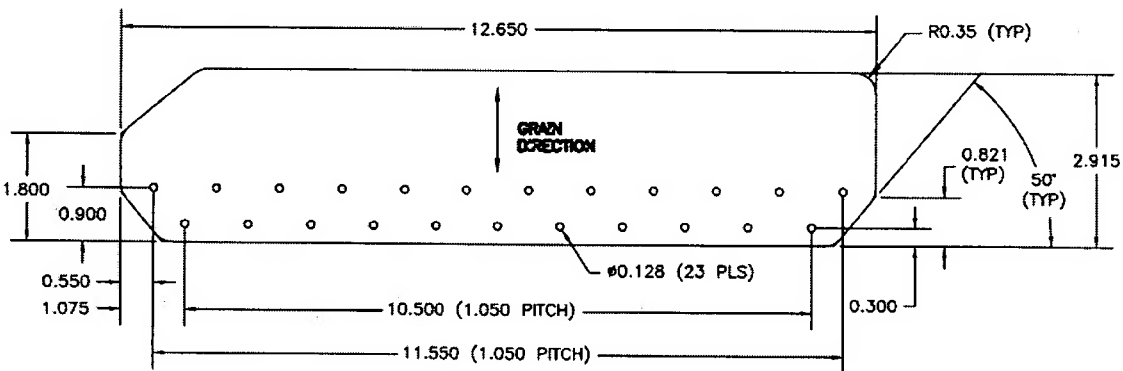
Measured by:	<i>gm</i>	Audited by:	<i>MS</i>	Prototype Approval:	N/A
Date:	<i>06/03/18</i>	Date:	<i>06/03/19</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	

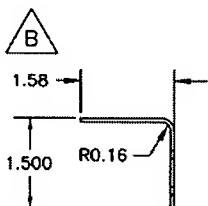


RELEASED
04.06.03

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
		D2175	SHEET 1 OF 1
DATE		TITLE	SCALE
04.06.03		ANGLE	1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	CHANGED DIMENSION	
C	00.09.11	UPDATE FINISH SPEC	
D	04.06.03	RE-DESIGN	



D2175 FLAT PATTERN



D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 26028



- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) ALL DIMENSIONS ARE IN INCHES

